

Date: Friday, 04/04/2008 9:21:57 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STEP (CASTING DETAIL)
<b>Job Number</b> : 38392	
<b>Estimate Number</b> : 10510	
<b>P.O. Number</b> :	<b>Part Number</b> : D25763
<b>This Issue</b> : 04/04/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2576 REV G
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : G
<b>Previous Run</b> : 33321	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 14/04/2008 <b>Qty:</b> 100 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JO 08.04.4</u>	
<b>Comment</b> : Est: E 02.08.19 Consolidated D2576-1 and D2576-3 KJ/RF	

Est Rev:D As per Rev G 07-09-05 JLM Verified By:EC

## Additional Product

Job Number:



**Seq. #:** **Machine Or Operation:** **Description :**

1.0 D25761 Step (Casting Detail)



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
1	D2576-1	Step (Casting Detail)	<del>B38282</del> 38420

JL 08/05/23 (96)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



**Comment:** HAAS1

1- Machine as per Folio FA332 and Dwg D2576

2- Deburr

mk/JL 08/05/23 (96)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

mk/JL 08/05/23 (96)

4.0 QC8 SECOND CHECK



**Comment:** SECOND CHECK

JL 08.05.23 96

5.0 PACKAGING 1 PACKAGING RESOURCE #1



**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: Spd tube Cell

DP

8-5-28

(96)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2576-3 PAR #: N/A Fault Category: Prod / Machined <sup>Parts</sup> NCR: Yes No DQA: A Date: 08/05/30  
 QA: N/C Closed: D Date: 08/05/30

NCR: 38392		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/05/23	2	4 parts lifted while machining dimension 125 is under tolerance - are parts acceptable?		Scrap and Destroy no Rephee Qty 4	J.L.			
		Re operator error <sup>wasn't</sup> <del>was</del> sitting Ptat on mouse						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 38392

Part Number: D25763

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

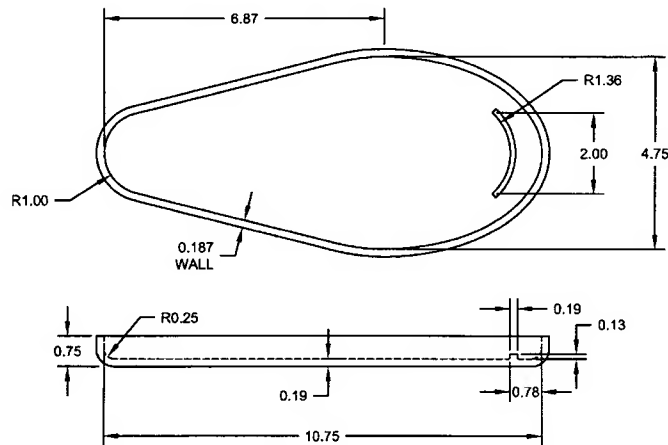
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

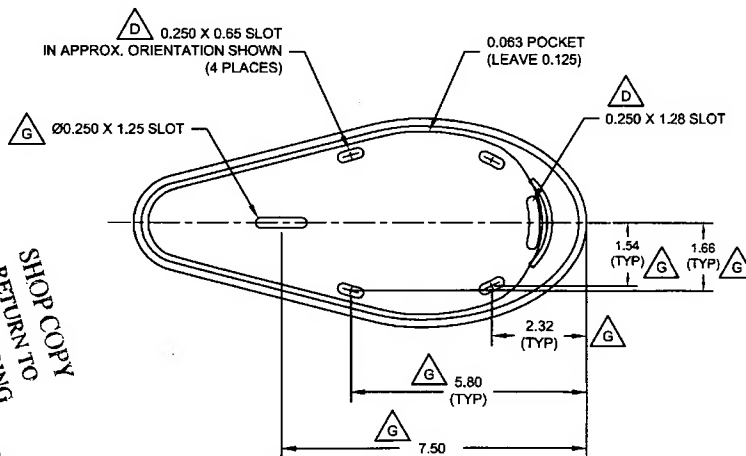
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





**D2576-1 CASTING**



**D2576-3 MACHINING DETAIL**  
(MAKE FROM D2576-1)

- NOTES:**
- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
  - 6) IDENTIFICATION: NONE

**RELEASED**

07.08.21

G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
REV.	DESCRIPTION	BY	DATE
DESIGN	4	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	3		
CHECKED	PH	DRAWING NO.	REV. G
MFG. APPR.	21	D2576	SHEET 1 OF 1
APPROVED	11	TITLE	SCALE
DE APPR.	11	STEP	1:3
DATE	07.08.15	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NO. 38372  
WORK ORDER  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY